

Date: Wednesday, 3/7/2007 8:38:13 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 3" OUTER TUBE		
Job Number	: 31032					
Estimate Number	: 10796					
P.O. Number	: N/A		Part Number	: D26001190		
This Issue	: 3/7/2007	S.O. No. : N/A	Drawing Number	: D2600 REV D1		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: D1		
Previous Run	: 24841		Material	: N/A		
Written By			Due Date	: 3/20/2007 Qty: 80 Um: Each		
Checked & Approved By						
Comment	: Est Rev.A 99.08.18 Was 2600-1 added -240 for length EC Est Rev.B 07.02.28 Changed length to -190 LL					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	-PURCHASING Comment: PURCHASING Issue P/O: <u>3263</u> 4249 07-07-25 CLo7/03/08 80 a) Extrude as per Dwg D2600 (190" long) b) Material: 6061-T6 c) Tool: MH-18870 Bon L * 897121 d) Material certification is required.
2.0	D26001190P	Extrusion Round 3" 206
3.0	PACKAGING 1	PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached 7/8/18 SP
4.0	QC6	DIMENSIONAL CHECK Comment: DIMENSIONAL CHECK 7/8/06 82
5.0	PACKAGING 1	PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: L6 JB 7-8-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/09/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 8:38:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3" OUTER TUBE

Job Number: 31032

Part Number: D26001190

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(82)

Comment: FINAL INSPECTION/W/O RELEASE

DSTKIS/19

Job Completion



11 Apr 9-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>DKY</i>	DRAWN BY <i>DKY</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
D1	01.04.17	ADD PART NUMBERS & DIE NUMBERS	<i>#GP</i>

RELEASED

18.08.25 DS

GENERAL NOTES

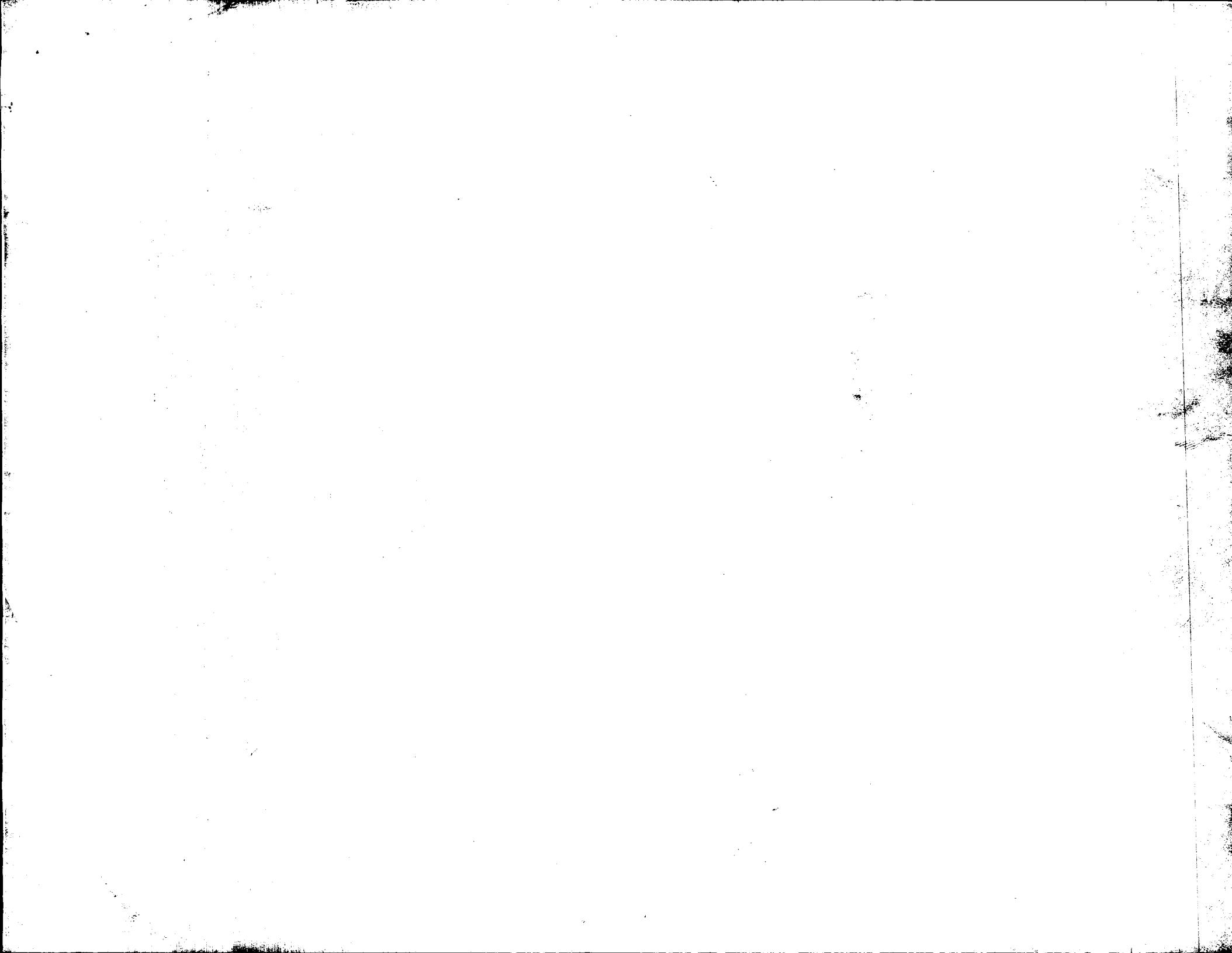
1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
 MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
 MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
 TO ASTM STANDARD B221 BY AN APPROVED TESTING
 FACILITY TO ENSURE THAT THE BATCH MEETS THE
 ABOVE MINIMUM MECHANICAL PROPERTIES.

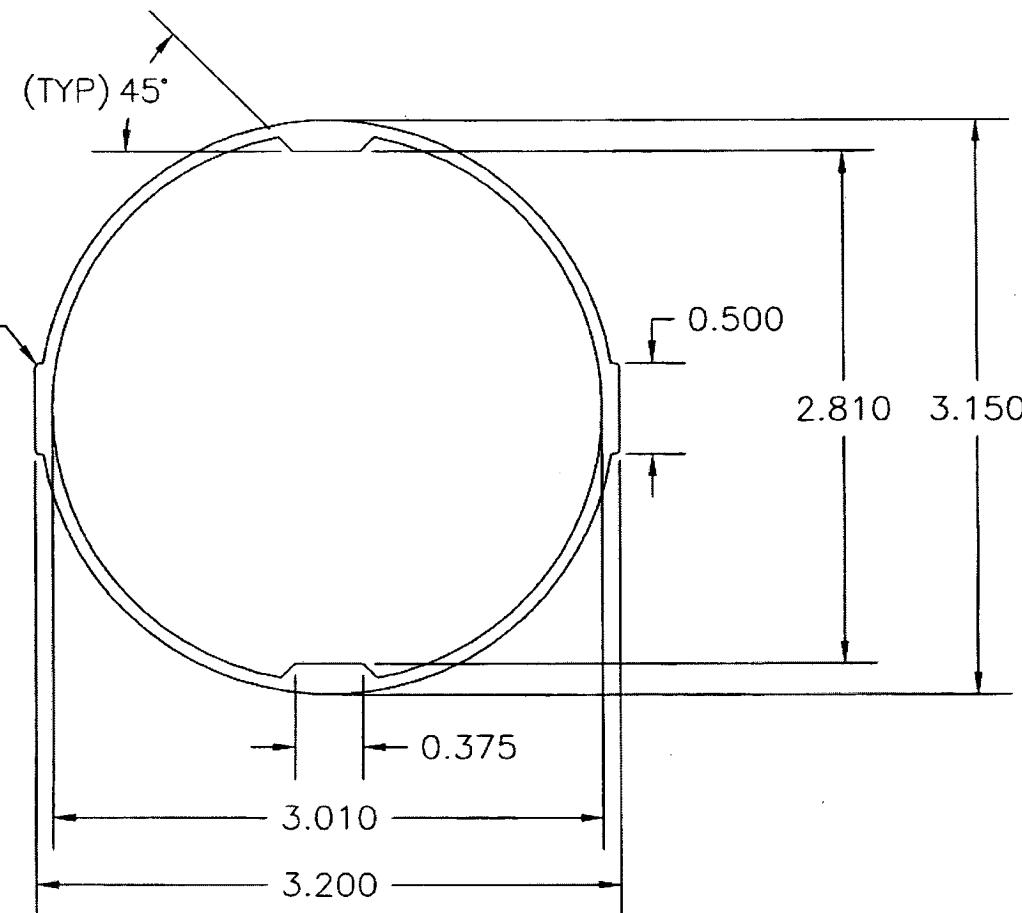
2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

SHOP COPY
 RETURN TO
 ENGINEERING
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. *31032*



DART

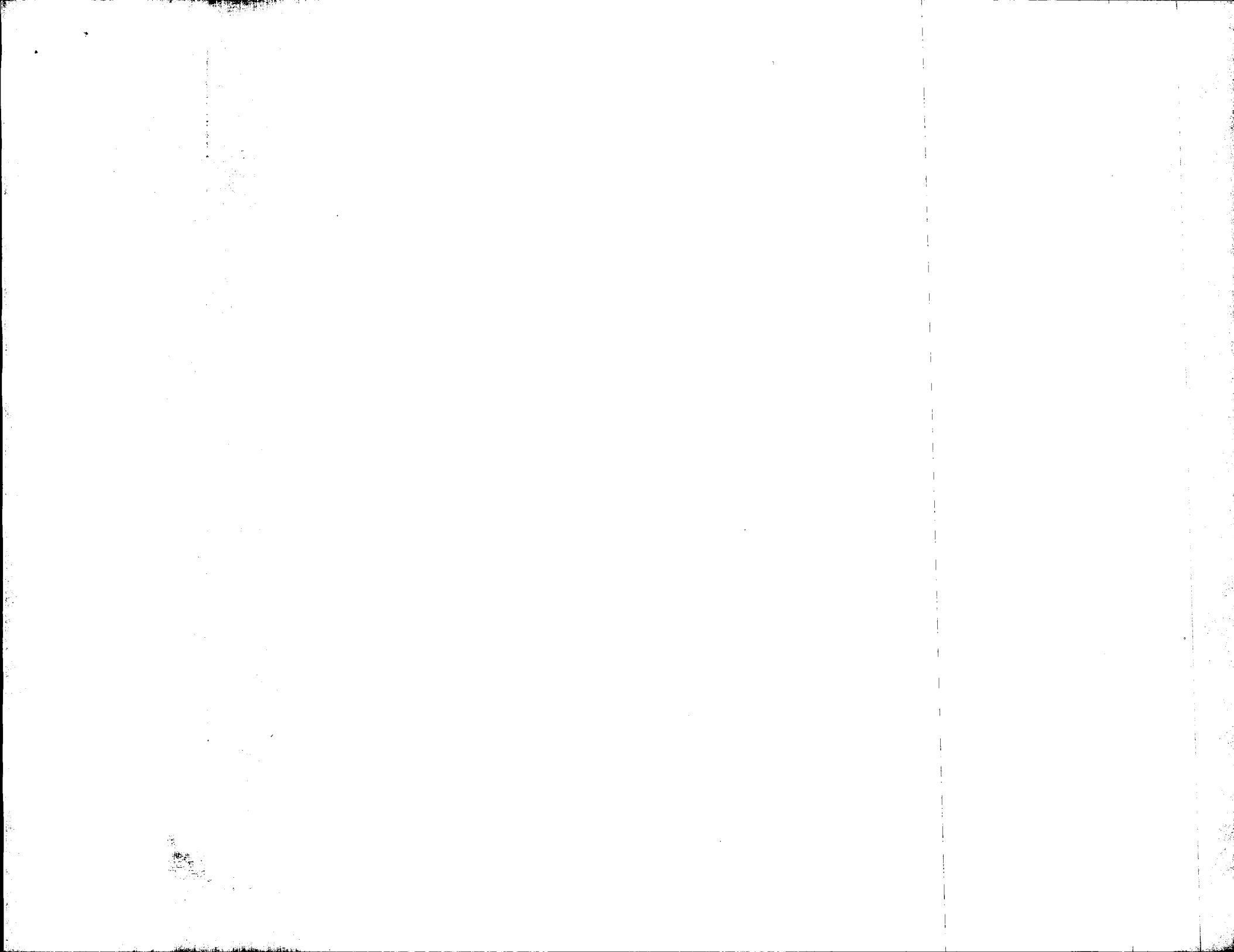
DESIGN <i>MF</i>	DRAWN BY <i>WJ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>JG</i>	DRAWING NO. D2600
DATE 98.08.20	TITLE EXTRUSION	SHEET 2 OF 5 SCALE 1:1

RELEASED
98.8.25 DSD2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
OR BON L DIE # 897121 (PREFERRED CHOICE)

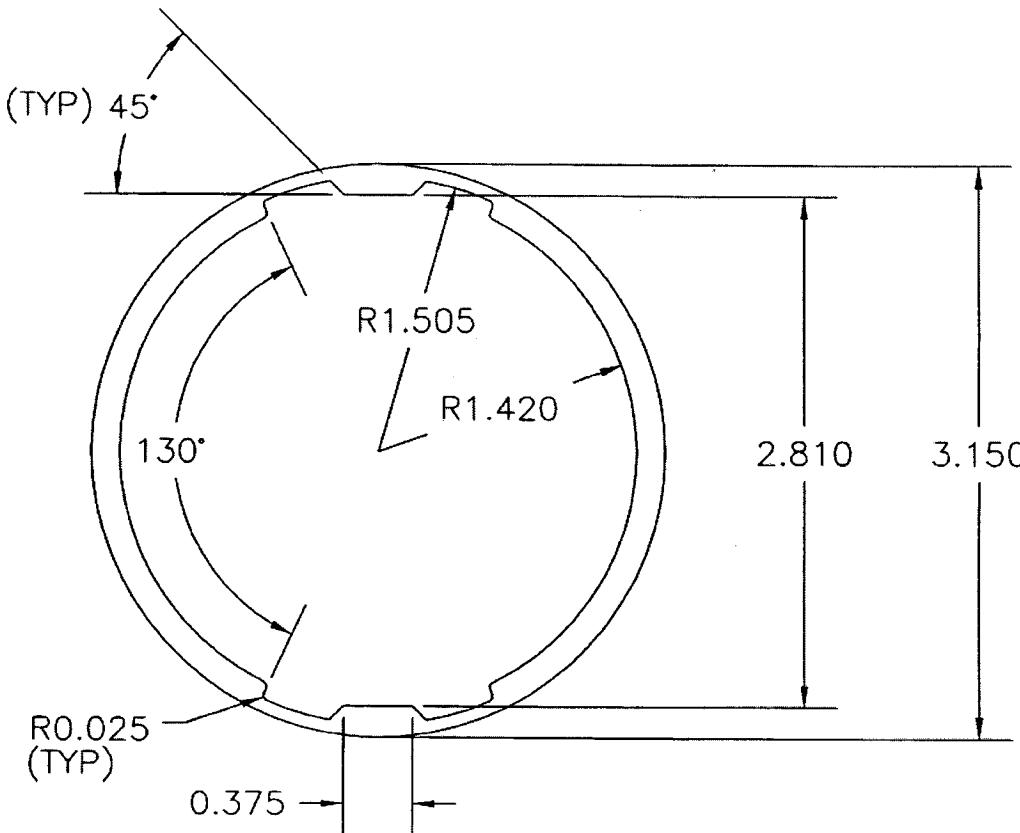
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

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WORK ORDER
NO. *3032*



DART

DESIGN <i>MH</i>	DRAWN BY <i>MH</i>	DART AEROSPACE LTD	
CHECKED <i>KE</i>	APPROVED <i>JF</i>	DRAWING NO. D2600	
DATE 98.08.20	TITLE EXTRUSION	SHEET 3 OF 5	REV. D
		SCALE 1:1	

RELEASED
98.8.25 DSD2600-3

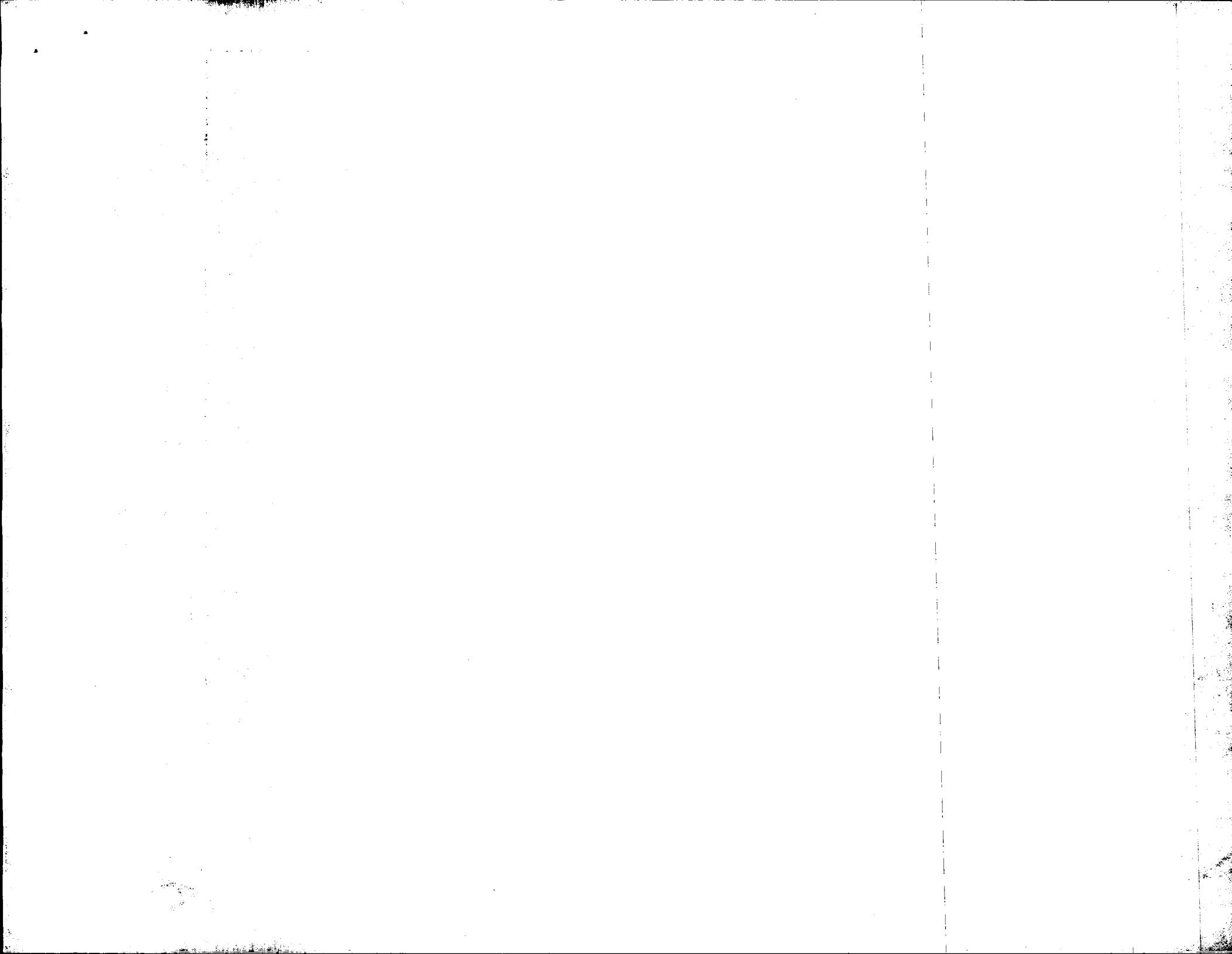
MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)

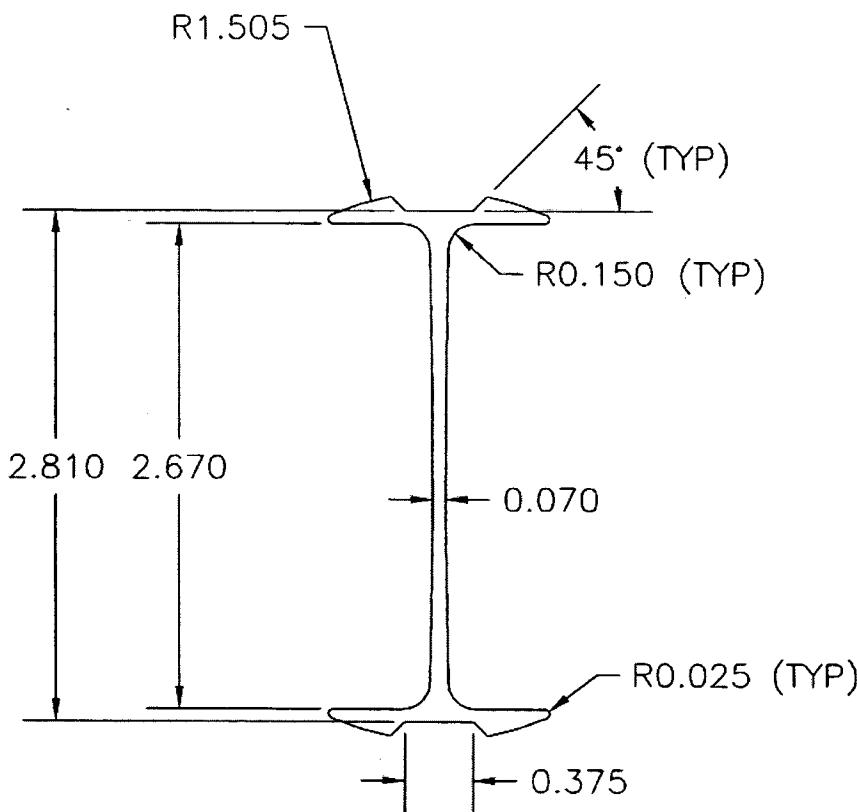


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WORK ORDER
NO. 31032



DART**RELEASED**
98.8.25. DS

DESIGN <i>MJ</i>	DRAWN BY <i>WJ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>JL</i>	DRAWING NO. D2600
DATE 98.08.20	SHEET 4 OF 5	TITLE EXTRUSION
	REV. D	SCALE 1:1

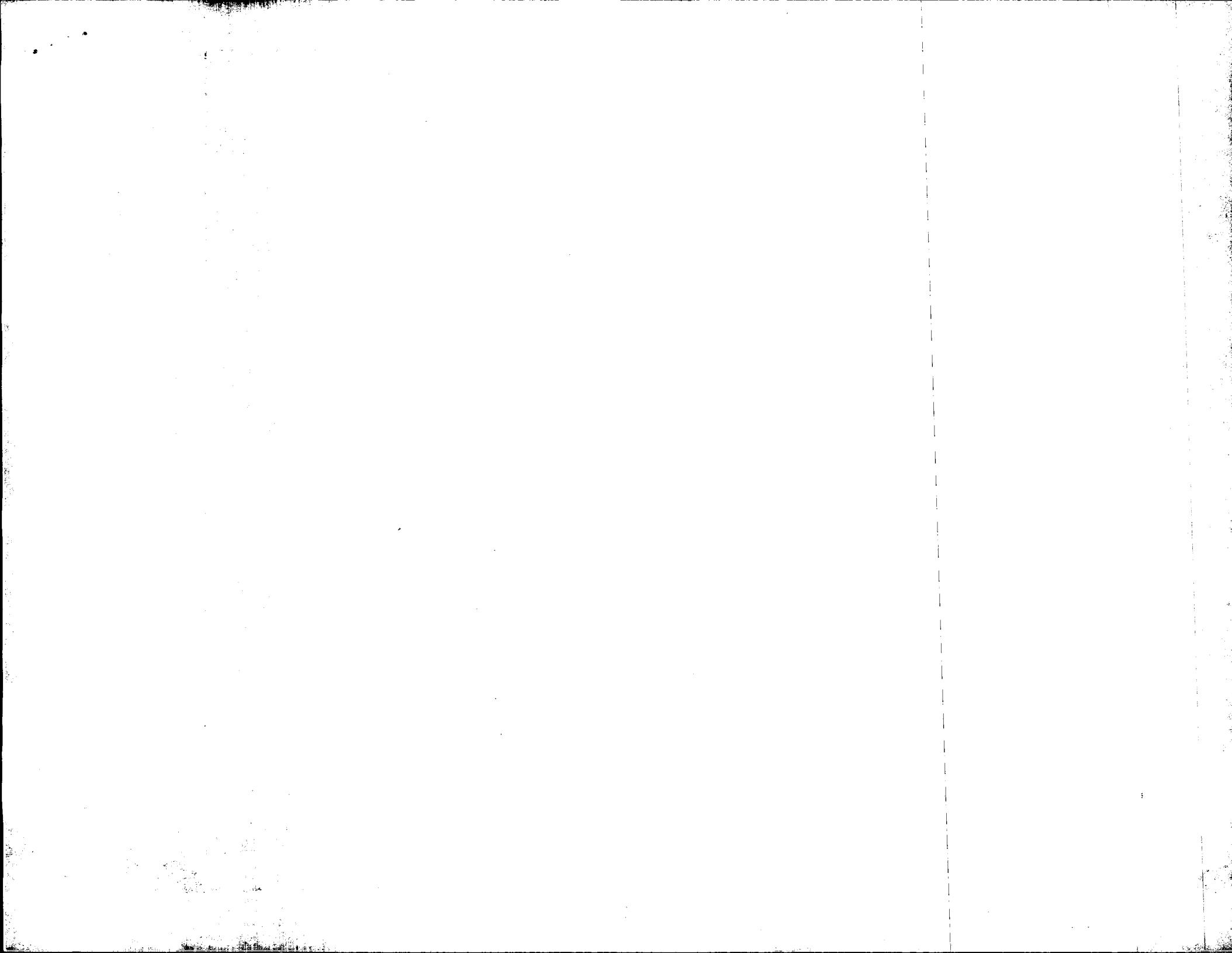


D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871

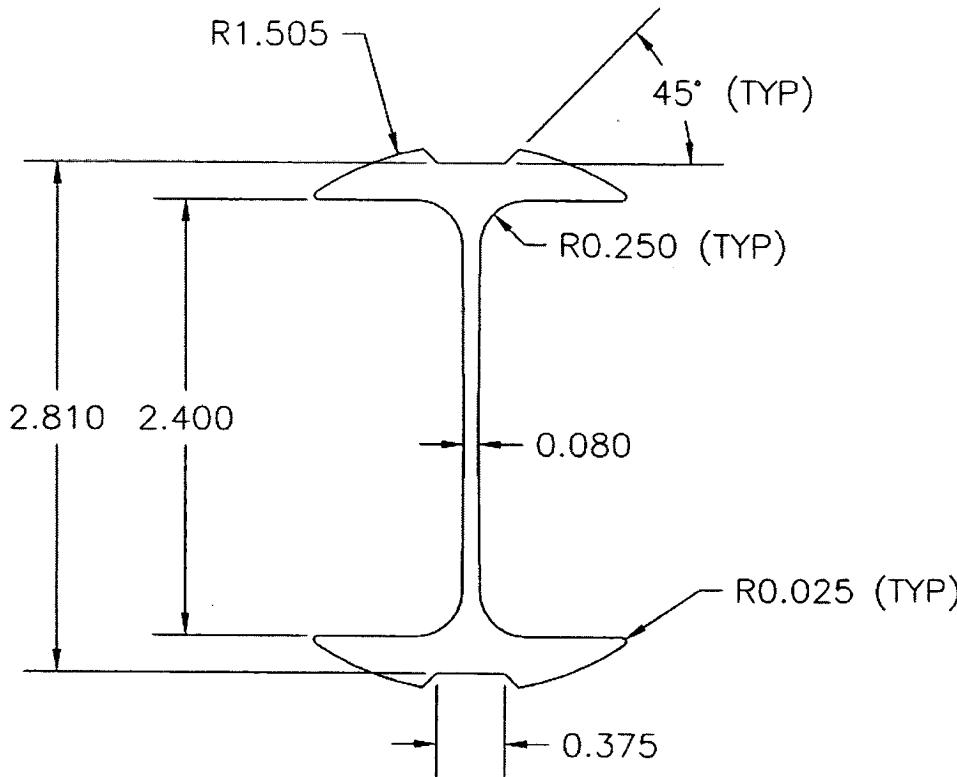
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)

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WORK ORDER
NO. 21032



DART

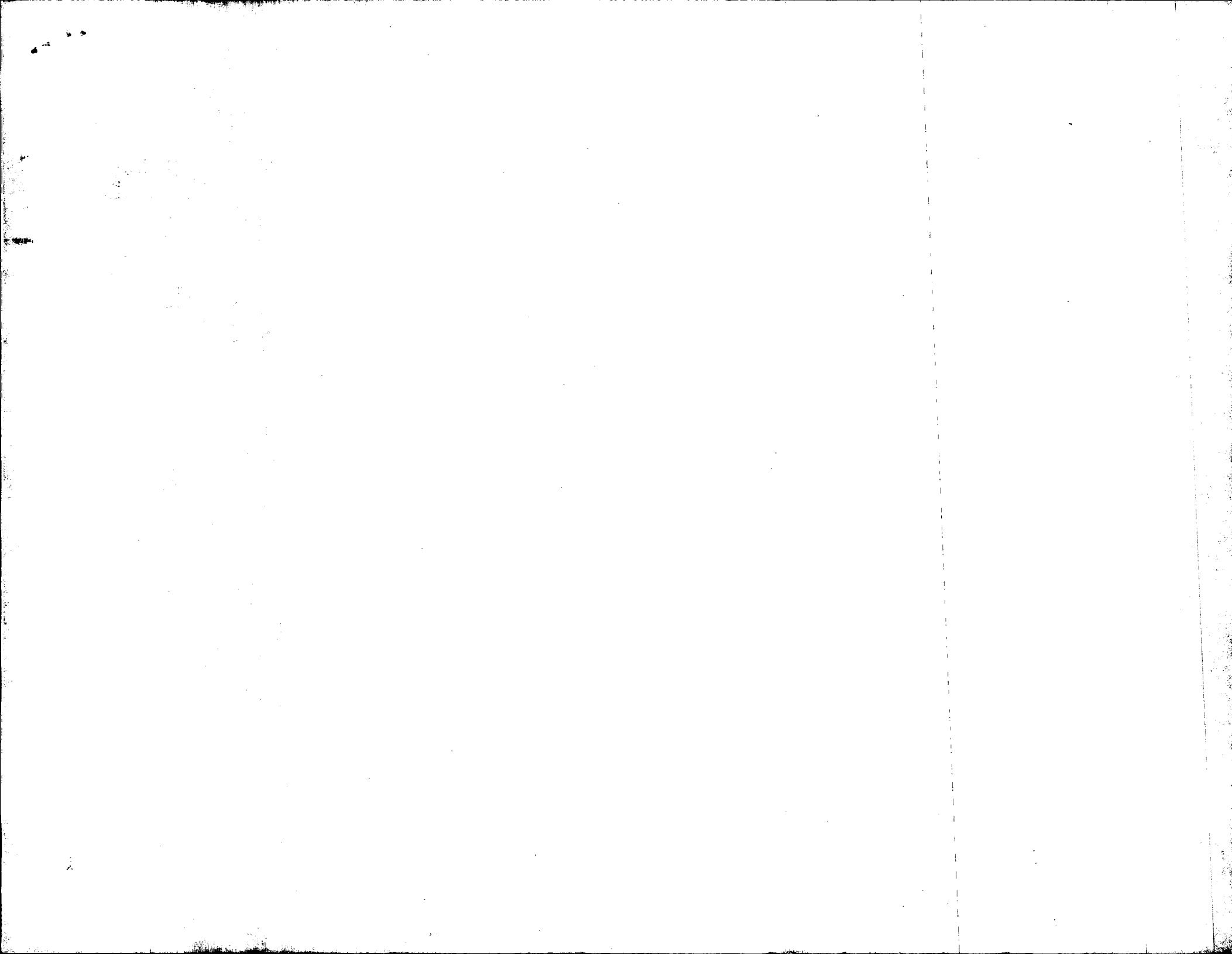
DESIGN <i>M</i>	DRAWN BY <i>M</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>S</i>	DRAWING NO. D2600
DATE 98.08.20	TITLE EXTRUSION	REV. D SHEET 5 OF 5 SCALE 1:1

RELEASED
98.8.25 DS

D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)

DI
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WITHOUT NOTICE
WORK ORDER
31032





CERTIFICATE OF COMPLIANCE

BON L CANADA INC

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Print Date	Part No.	Serial No.	Page
08/03/07	163764	79932	1
4249	00352652	79932010	8/03/07

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

Item No.	Part No.	Item Description	Cost Part
1.000	DAA-897121-3	190 th Mill 6061 T6	D2600-1-190
Gross Weight	656 KGS		
Net Wt.	628 KG	82 PC	396 M
Specification			AMS-QQ-A-200/8 & ASTM B221-00

Mechanical Tests:

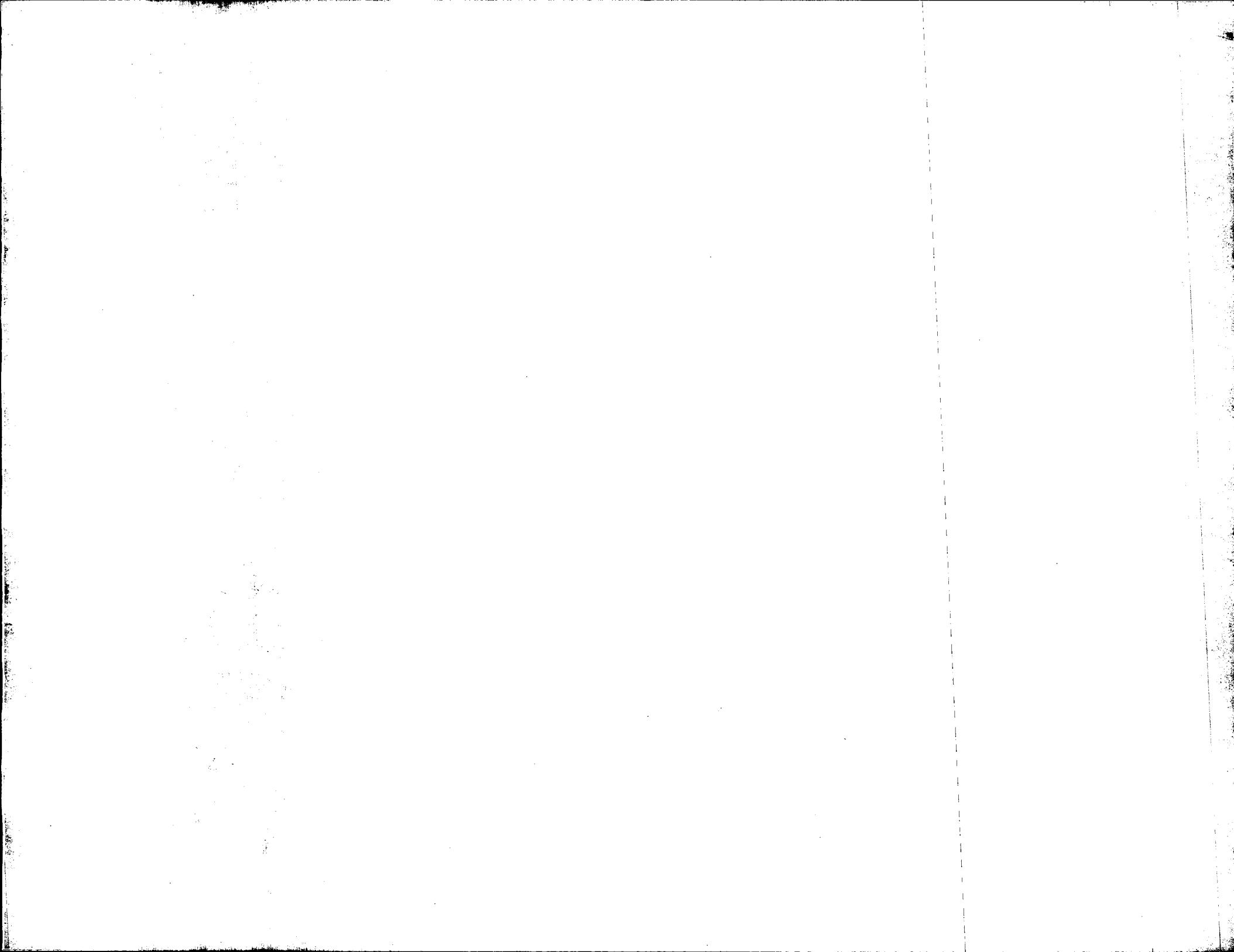
Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend Drift	HREW
1	275.9 / 40.0	213.1 / 30.9	11.5	.0	.92	

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.66	.29	.29	.06	.92	.06	.000	.06	.000	.009	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

D. VanBakel, QA Manager Signed for Bon L Canada



CANADA INC.

**WILLIAM L. BONNELL COMPANY, INC.
IN L MANUFACTURING COMPANY**
SUBSIDIARIES OF TREDEGAR CORPORATION
FILIALES DE LA CORPORATION TREDEGAR

BOV

**INVOICING COMPANY AND LOCATION
BUREAU DE FACTURATION**

BON L CANADA INC
500 EDWARD AVENUE
RICHMOND HILL ON L4C 4V9

~~ACCT# 00046024~~
~~DIE A~~

OSPACE LTD.
RDEEN ST.
RY

3-632-5200

ENT	ORDER DATE DATE DE LA COMMANDE	CUST. P.O. NO.
	07/25/07	4249

SOLD TO/VENDU À

DART AEROSPACE LTD.
1270 ABERDEEN ST.

ON HAWKESBURY
CN K6A 1K7

ON
CN

PHONE 613-632-5200

冰冰冰冰
*O/P
冰冰冰冰

LOC/USINE	TRAILER NO./N° DE REMORQUE	SALESMAN/VENDEUR
RH	OTTAWA	59358

BILL OF LADING NUMBER/N° DE CONNAISSEMENT
00352652

**SHIPPING MANIFEST
BORDEREAU D'EXPÉDITION**

MANIFEST DATE/DATE D'EXPÉDITION

08.03.07

~~60005~~ SALES ORDER NUMBER/N° DE COMM.

**REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE.
RÉFÉREZ-VOUS À CES
NUMÉROS POUR TOUTE
CORRESPONDANCE.**

CREDIT REP
REP. DU CRÉDIT
HAMBROOK, PAU
905-508-3250

SALES REP
REP. DES VENTES

FIELD SALES REP
REP. RÉGIONAL DES VENTES
Kutter A
450-435-6551

CUST SERVICE REP
REP. SERVICE CLIENTÈLE
Burton D
905-427-2227

S WILL BE ACCEPTED FOR CREDIT WITHOUT PERMISSION
MÉRIEL NE SERA ACCEPTÉ POUR CRÉDIT SANS AUTORISATION

70001
Cert No: 163764

Certificate of Compliance

Page - 1
Date - 8/27/07

BON L CANADA INC
500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Cert Date . . . 08/03/07
Sales Order . . . 9932
Cust PO . . . 4249
B/L No . . . 00362652
Lot . . . 79932010

Sold to: 46024
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

Ship to: 46024
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

Item Number	Part Number	Item Description	Gross KGS	Net Quantity
1.000	DAA-897121-3	190" Mill 6061 T6	656	628 KG 82 PC 396 M 2 PKG

Cust part: D2600-1-190
Specification: AMS-QQ-A-200/8 & ASTM B221-00

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift	HREW
1	324.9 / 47.1	286.9 / 41.6	10.4	.0	.93	

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	CA	V	TI	ZR	OTHER
.66	.29	.29	.06	.92	.06	.000	.06	.000	.009	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

D. VanBakel, QA Manager Signed for Bon L Canada